

Amendments to the Claims

This listing of claims will replace all prior versions of the claims in this application:

Listing of the Claims:

Claims 1-34 have been cancelled.

35. (previously presented) An orbital welding process for joining adjacent ends of two heavy wall duplex stainless steel tubes comprising

- (a) applying a high refractory flux to the heat affect zone formed by the adjacent tube ends to be welded, and
- (b) arc welding the adjacent tube ends together in a single orbital pass using a non-pulsed arc.

36. (previously presented) The process of claim ~~29~~³⁵, wherein the flux includes at least one of silica, titania, magnesia, chromia and a titanium oxide.

37. (previously presented) The process of claim 36, wherein the refractory flux comprises a mixture of Cr_2O_3 , SiO_2 and an oxide of titanium.

38. (previously presented) The process of claim 37, wherein the refractory flux comprises a mixture of about 30 to 70 wt.% of a titanium dioxide, about 20 to 76 wt.% Cr_2O_3 , and about 5 to 27 wt.% SiO_2 .

39. (previously presented) The process of claim 38, wherein the wall thickness of the tubing being welded is greater than 2 mm.